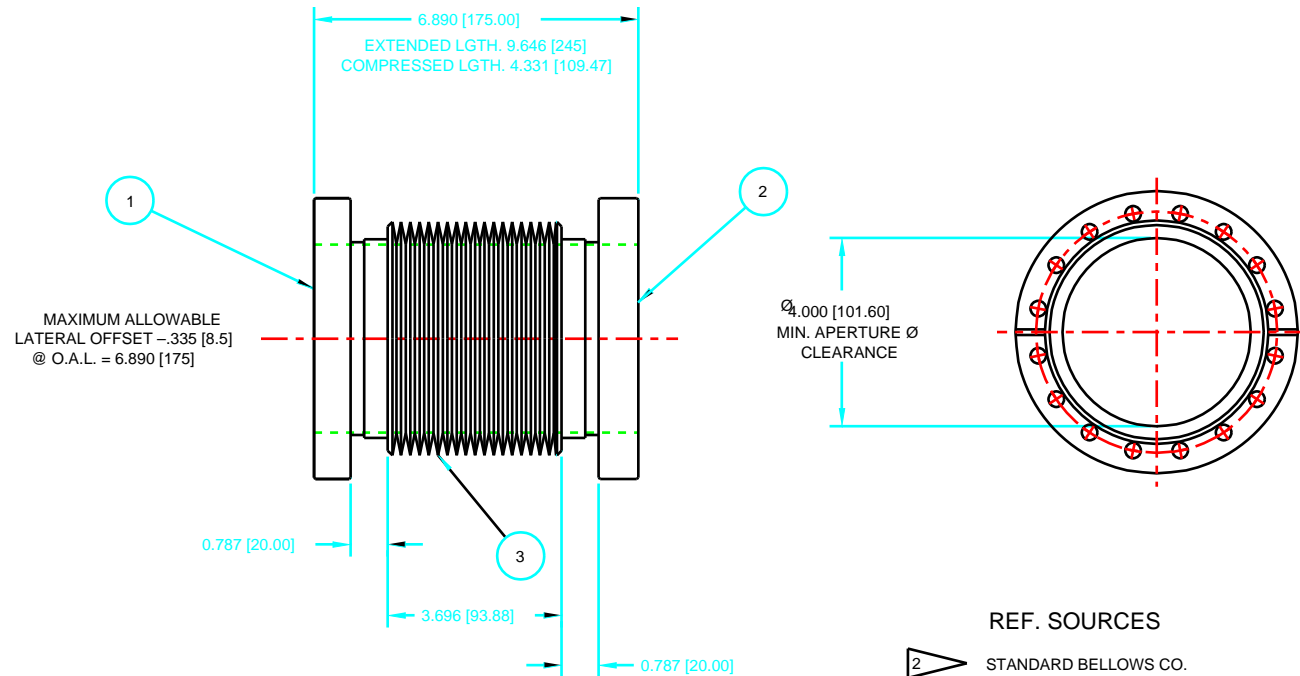


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NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL

Du PONT CEC 24-120B

VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

- 2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096
- 1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #497 - 400 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100026	6" CF. ROTATABLE FLANGE		1
1	MDC'S CAT. #110026	6" CF. NONROTATABLE FLANGE		1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES.		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGLES	A09232		

± .03 (1.7620)	± .25 *	DRAWN BY	DATE	CHIEF DESIGN ENGINEER	DATE	TITLE
± .01 (0.25)		MUSCIA	2/17/93	D. SHU	2/22/93	ADVANCED PHOTON SOURCE
± .005 (0.127)		CHECKED BY		OP. LEADER	2/22/93	V2 - 83 WELDED BELLOWS ASSY.

SURFACE FINISHES		DESIGNER	RESPONSIBLE ENGINEER	APPROVED/RELEASED	PROJECT NO.	
125		MUSCIA	D. SHU	2/22/93		

REMOVE ALL BURRS AND BREAK SHARP EDGES TO BL.		MATERIAL		SCALE		SIZE		DRAWING NUMBER	
SURFACE FINISHES TO BE IN ACCORDANCE WITH LATEST AND 944		SEE PARTS LIST		HALF		C		4105090702-830000-00	

REWORKING & TOLERANCES IN ACCORDANCE WITH LATEST AND 944		SHEET		1 of 1		1		1	
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SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				
1				
2				
3				

4

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